

**EXHIBIT 18**

**UNREDACTED VERSION  
OF DOCUMENT  
SOUGHT TO BE SEALED**

<b>Velodyne®</b>	<b>MPI, LASER FIBER ATTACH &amp; ALIGNMENT, VLP-16 &amp; HDL32E</b>	<b>MPI # : 70-0303</b>
Product Line: HDL32E/VLP-16	MANUFACTURING PROCESS INSTRUCTIONS	Rev: A Page: 1 of 23

**Engineering Change History**

ECO	REV	DESCRIPTION OF CHANGE	AUTHOR	REQUESTOR	DATE
002119	A	RELEASE TO PRODUCTION	R. Balderas	Alen Mekertichian	04/05/17

**EXHIBIT 1963**

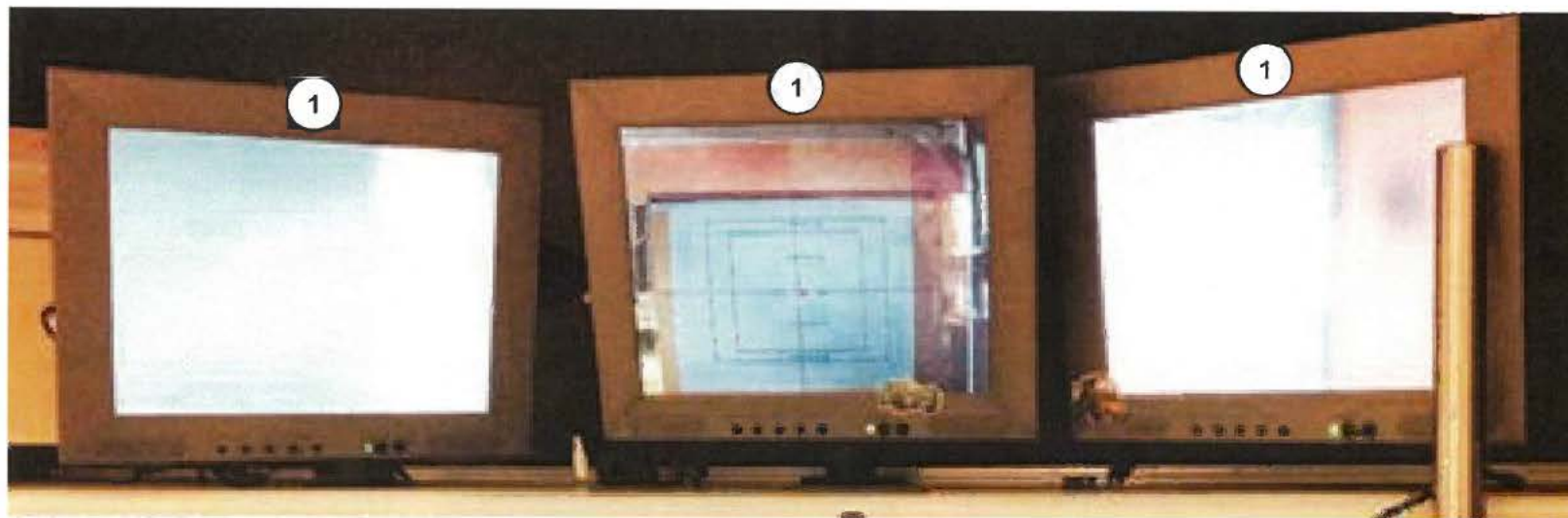
Witness:  
STEPHEN NESTINGER  
Date: 08.23.2017

Susan Magee CSR No. 11661

<b>Velodyne®</b>	<b>MPI, LASER FIBER ATTACH &amp; ALIGNMENT, VLP-16 &amp; HDL32E</b>	<b>MPI # : 70-0303</b>
Product Line: HDL32E/VLP-16	MANUFACTURING PROCESS INSTRUCTIONS	Rev: A Page: 2 of 23



<b>Velodyne®</b>	<b>MPI, LASER FIBER ATTACH &amp; ALIGNMENT, VLP-16 &amp; HDL32E</b>	<b>MPI # : 70-0303</b>
Product Line: HDL32E/VLP-16	MANUFACTURING PROCESS INSTRUCTIONS	Rev: A Page: 3 of 23




PART LIST					Item          Work          Verify          TQC
Item #	P/N	Item Description	UM	Qty	
1	N/A	MONITOR	EA	3	Operation: Tools Required



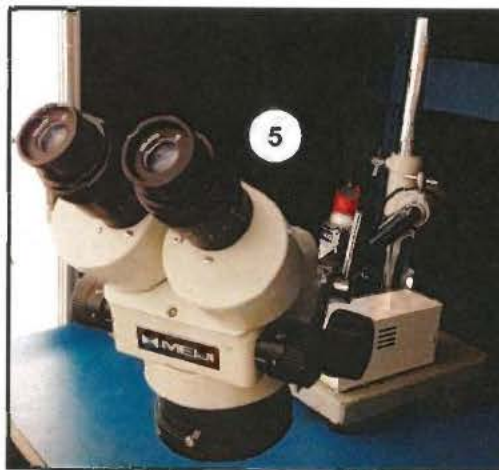
<b>Velodyne®</b>	<b>MPI, LASER FIBER ATTACH &amp; ALIGNMENT, VLP-16 &amp; HDL32E</b>	<b>MPI # : 70-0303</b>
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1



3



5



7



2



4



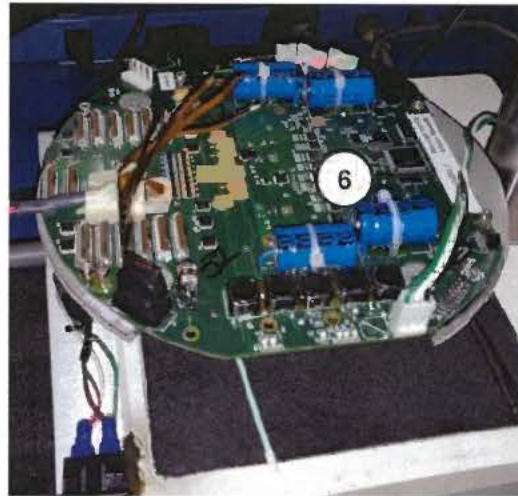
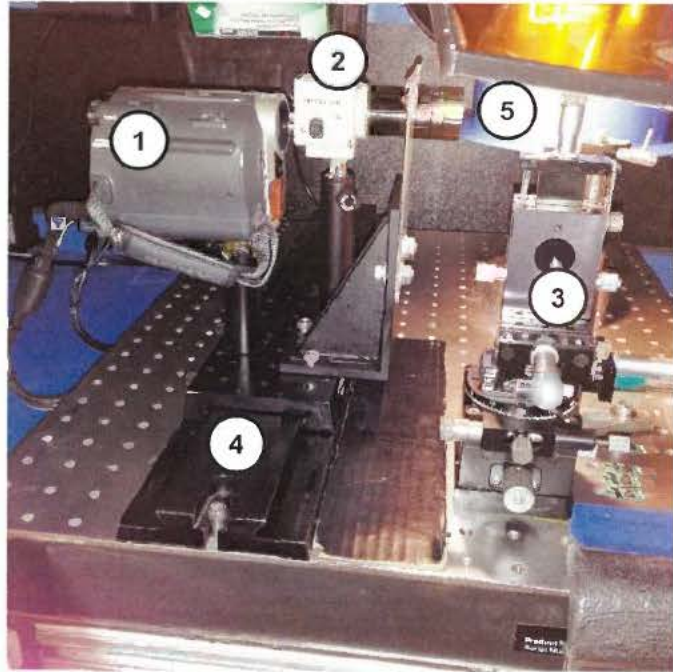
6

PART LIST				
Item #	P/N	Item Description	UM	Qty
1	N/A	AIR HOSE w/ FILTER AND DEIONIZER	EA	1
2	N/A	ESD STRAP	EA	1
3	N/A	UV LIGHT SYSTEM	EA	1
4	N/A	LASER BOARD TRAY	EA	1
5	N/A	MICROSCOPE	EA	1
6	91-0031	UV SAFETY GLASSES	EA	1
7	49-0064	OPTICAL ADHESIVE	EA	1

○ Item
 Work
  Verify
 ▲ TQC

**Operation: Tools Required**





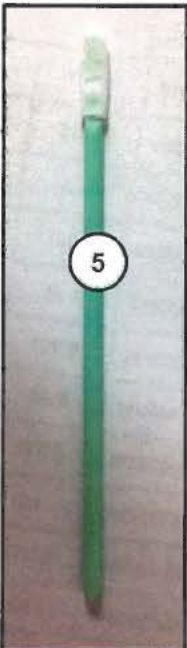

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<b>Product Line: HDL32E/VLP-16</b>	<b>MANUFACTURING PROCESS INSTRUCTIONS</b>	<b>Rev: A Page: 5 of 23</b>




PART LIST					<div> <div>○ Item</div> <div>■ Work</div> <div>● Verify</div> <div>▲ TQC</div> </div>	
Item #	P/N	Item Description	UM	Qty	Operation: Tools Required	
1	N/A	VIDEO CAMERA	EA	1		
2	N/A	HITACHI CAMERA	EA	1		
3	N/A	AXIS ALIGNMENT FIXTURE	EA	1		
4	N/A	ADJUSTMENT RAIL	EA	1		
5	53-59303	100um Optical Fiber	EA	1		
6	N/A	LASER POWER SUPPLY	EA	1		
7	95-0042	GLOVES, ANTISTATIC NITRILE	PR	1		




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PART LIST					<span style="border: 1px solid black; border-radius: 50%; padding: 2px;">○</span> Item <span style="background-color: yellow; padding: 2px; margin-left: 10px;">■</span> Work <span style="background-color: blue; color: white; border-radius: 50%; padding: 2px; margin-left: 10px;">●</span> Verify <span style="color: red; font-weight: bold; margin-left: 10px;">▲</span> TQC
Item #	P/N	Item Description	UM	Qty	
1	98-0001	ALCOHOL, ISOPROPYL, 99.8%	EA	1	<b>Operation: Tools Required</b>
2	91-0004	WIRE CUTTER	EA	1	
3	91-0012	TWEEZER	EA	1	
4	95-13701	BRUSH	EA	1	
5	95-0051	SWAB, CLEANROOM, POLYESTER, 0.0394" TIP	BG	1	
6	N/A	APPLICATION ADHESIVE TOOL	EA	1	

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PART LIST					<div style="display: flex; justify-content: space-around; align-items: center;"> <div style="text-align: center;">○ Item</div> <div style="text-align: center;">■ Work</div> <div style="text-align: center;">● Verify</div> <div style="text-align: center;">▲ TQC</div> </div>			
Item #	P/N	Item Description	UM	Qty				
1	N/A	LASER BOARD TRAY	EA	1	<div style="margin-top: 10px;"> <b>Operation:</b> Laser Tray           </div> <div style="margin-top: 10px; color: red;"> <b>Attention:</b> ESD Strapping and Nitrile Gloves is to be warned at all times during build.           </div> <div style="margin-top: 10px;">             1. Please note location designation for each slot in tray as indicated in photo.           </div>			









































